



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2858-2
Job Sheet 187216



Part No: D2858-2

Job Qty: 24 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	24 pcs		12/13/18	0.00	0.07	Bandsaw - 1		B.F 19-02-10
110	HAAS 4 Axis - B4B	24 pcs		12/13/18	0.00	6.58	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		B.F 19-02-10
							HAAS - 4 - B4B		
130	QC 8	24 pcs		12/13/18	0.00	0.00	QC 8 - 12		
							QC 8 - 14		9-19/02/12
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
140	Handfinish - 1-1 Chemical-B4B	24 pcs		12/13/18	0.00	0.46	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 -		



Container No: S152234



Part: D2858-2

Job No: 187216

Serial No/Batch: S152234

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/10/19

					B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/2/12
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	24 pcs	12/13/18	0.00 0.41	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	3/19-02-12
					Powdercoat - 4 - B4B	
160	QC 3	24 pcs	12/13/18	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	PD 19-02-13
						Plex 1/22/19 11:38 AM Dart.Hadley.Shannon

170 Packaging 3-1 - Stock - B4B

24
pcs

12/13/18

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4BPackaging 3 - 11 -
B4BPackaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
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B4BPackaging 3 - 17 -
B4BPackaging 3 - 18 -
B4BPackaging 3 - 19 -
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B4BPackaging 3 - 27 -
B4BPackaging 3 - 28 -
B4BPackaging 3 - 29 -
B4BPackaging 3 - 30 -
B4BPackaging 3 - 31 -
B4BPackaging 3 - 32 -
B4BPackaging 3 - 33 -
B4BPackaging 3 - 34 -
B4BPackaging 3 - 35 -
B4BPackaging 3 - 36 -
B4BDAS
6 FEB 14 2019
9-89

57012

180 QC 21 - SA

24

12/13/18

0.00 0.00

QC 21 - SA - 21

DAS
21 FEB 14 2019
9-89

pcs

QC 21 - SA - 70

Part Op 100 - Bandsaw *cut at 5.850 16 blanks make 3 parts*
 Descriptions: 110 - HAAS CNC Vertical Machine 1-Machine per folio FA941
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

MAT
used
3.948'

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X1.500	6061-T6 Bar 1.250 X 1.500	3.6000 ft (.15 ea)	100-Bandsaw - 1	<u>S136474</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X1.500	4	15	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171	ϕ 0.172"	
2	Hinge Bracket	0.400inches + 0.005 - 0.000	0.405 0.400	ϕ 0.400"	
3	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	R 0.125"	
4	Hinge Bracket	0.328inches $\pm$ 0.010	0.338 0.318	0.328"	
5	Hinge Bracket	0.820inches $\pm$ 0.010	0.830 0.810	0.820"	
6	Hinge Bracket	1.476inches $\pm$ 0.010	1.486 1.466	1.476"	
7	Hinge Bracket	0.342inches $\pm$ 0.010	0.352 0.332	0.342"	
8	Hinge Bracket	0.875inches $\pm$ 0.010	0.885 0.865	0.875"	
9	Hinge Bracket	1.560inches $\pm$ 0.030	1.590 1.530	1.563"	
10	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137	0.150"	
11	Hinge Bracket	0.717inches $\pm$ 0.010	0.727 0.707	0.718"	
12	Hinge Bracket	0.697inches $\pm$ 0.010	0.707 0.687	0.697"	
13	Hinge Bracket	0.229inches $\pm$ 0.010	0.239 0.219	0.231"	
14	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	R 0.125"	
15	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	0.063"	
16	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	0.063"	
17	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116	0.127"	
18	Hinge Bracket	0.630inches $\pm$ 0.010	0.640 0.620	0.632"	
19	Hinge Bracket	0.354inches $\pm$ 0.010	0.364 0.344	0.354"	
20	Hinge Bracket	0.965inches $\pm$ 0.010	0.975 0.955	0.968"	
21	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166	ϕ 0.167"	



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Job Sheet 187216



Part No: D2858-2

Job Qty: 24 ea

Part Name: Hinge Bracket



Part Weight: 0 lbs

Job Created: 11/29/18

Due Date: 12/13/18

Type: ~~SOLD~~

Note: DWG REV C IPP C 00.06.22 Removed

Ship Via:

Priority: Medium

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Dave M19

Bill of Materials

Job Roll

Op No	Operation	Qty	Start Date	Due Date	Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter	Supplier	
90	Start up Operation	24 Ea	12/13/18	12/13/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	24 pcs	12/13/18	12/13/18	0.00	0.07	Bandsaw1		
110	CNC Vertical Machining	24 pcs	12/13/18	12/13/18	0.00	6.58	HAAS1-2		
130	QC	24 pcs	12/13/18	12/13/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	24 pcs	12/13/18	12/13/18	0.00	0.46	HandFinish1		
150	Powdercoat	24 pcs	12/13/18	12/13/18	0.00	0.41	Powdercoat1		
160	QC	24 pcs	12/13/18	12/13/18	0.00	0.00	QC3		
170	Packaging	24 pcs	12/13/18	12/13/18	0.00	0.00	Packaging3-1		
180	QC21-SA	24 Ea	12/13/18	12/13/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine per folio FA941

Descriptions: 150 - START TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X1.250	6061-T6 Bar 1.50 X 1.25	3,6000 ft (.15 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X1.250	4	3	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171		
2	Hinge Bracket	0.400inches + 0.005 - 0.000	0.405 0.400		
3	Hinge Bracket	0.125inches ± 0.010	0.135 0.115		
4	Hinge Bracket	0.328inches ± 0.010	0.338 0.318		
5	Hinge Bracket	0.820inches ± 0.010	0.830 0.810		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

6	Hinge Bracket	1.476inches $\pm$ 0.010	1.486 1.466
7	Hinge Bracket	0.342inches $\pm$ 0.010	0.352 0.332
8	Hinge Bracket	0.875inches $\pm$ 0.010	0.885 0.865
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18	Hinge Bracket	0.630inches $\pm$ 0.010	0.640 0.620
19	Hinge Bracket	0.354inches $\pm$ 0.010	0.364 0.344
20	Hinge Bracket	0.965inches $\pm$ 0.010	0.975 0.955
21	Hinge Bracket	0.166inches $\pm$ 0.005 - 0.000	0.171 0.166

Plex 11/29/18 11:42 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					